

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017651**Date Inspected:** 24-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (11AW-11BW)

This QA Inspector along with QA Inspector Mr. Manjunath S Math performed dimensional joint survey inspection on the B1, B2, B3, B4, T1 and T2 work point across transverse splice joints to verify the skin flatness using 5 meter string line, 600mm and 630mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11AW to Segment 11BW (PP 97 to PP 98)

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (10CW)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The members are identified as corner assembly plate X3S. The weld designations reviewed are as follows:

PP 92 to PP 94

SEG063E-170 and 172

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SEG063D-028, 030, 045 and 048

OBG # TRIAL ASSEMBLY YARD (10CW)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an UT report for this date. The members are identified as FL3 Partial diaphragm. The weld designations reviewed are as follows:

SSD25-PP92-029 and 047

SSD25-PP93-099 and 117

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11BE-11CE)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 009 in the (1G) flat position on deck panel piece mark no. OBW11. The location was the transverse splice weld joining segment 11BW and 11CW. The welder ID was 047353. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-1.

OBG # TRIAL ASSEMBLY YARD (11BE-11CE)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 007 in the (1G) flat position on deck panel piece mark no. OBW11. The location was the transverse splice weld joining segment 11BW and 11CW. The welder ID was 052763. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1T-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan
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Quality Assurance Inspector

Reviewed By:	Peterson,Art
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QA Reviewer
